

Work Order ID 133398

Monday, June 08, 2015 4:00:17 PM

133398

Page 1

Item ID: D2372-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Cam Lever

Stop ***NS2***

Start Date: 6/08/15 Start Qty: ~~6.00~~

10 JUN 10 2015

~~*R*~~

Cust Item ID:

Required Date: 6/08/15 Req'd Qty: ~~6.00~~

~~*G*~~

Customer:

Reference:

Approvals: Process Plan: MLJ Date: JUN 09 2015 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2372	B

100 0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 28761
Possible Supplier: Essentra
Supplier part#: KCL-208
C O F C is required

CY JUN 10 2015 10

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

10 x 8015-06-15

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

(12)

DAS
38
9-89

JUN 15 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified ☐	☐	Past Due	☐				

Monday, June 08, 2015 4:00:17 PM

133398

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Cam Lever

Start Date: 6/08/15 **Start Qty:** 6.00 ***6***

Cust Item ID:

Required Date: 6/08/15 **Req'd Qty:** 6.00 ***6***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

130

Identify as per dwg & Stock Location:

0.00

130

Packaging

Memo

0.00

Packaging

JUN 16 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ JUN 18 2015

MLJ JUN 17 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Monday, June 08, 2015 4:00:16 PM

133398

D2372-1

Start Date: 6/08/15**Required Date:** 6/08/15

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 12.02.07 new issue DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
KCL-208 *KCI -208* Cam Lever		Purchased	No			110	Each	0.0000	1	610d 10x80 K-06-F	**		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

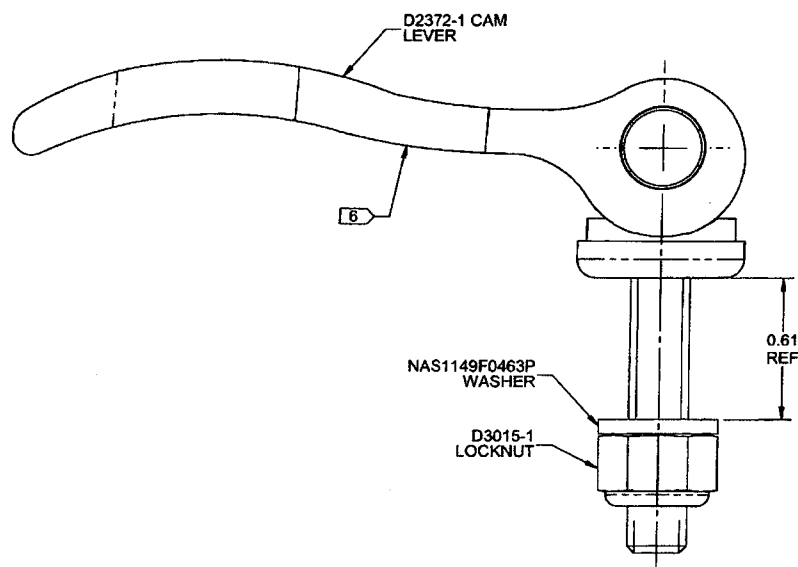
QA Closed: _____ Date: _____

Work Order update only ☐

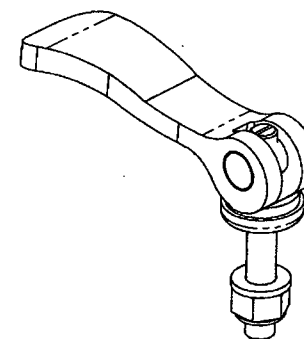
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mis-labeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D2372	QUICK RELEASE
1	1	D2372-1	CAM LEVER
2	1	D3015-1	LOCKNUT
3	1	NAS1149F0463P	WASHER

SPECIFICATION CONTROL DRAWING



D2372 QUICK RELEASE



SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
133398 MJS
15-06-09

RELEASED
R 2012-02-06
JW

NOTES:

- 1) MATERIAL: SEE SHEET 2
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2372" AND B/N "BXXXXX" PER DART QSI 044 6.5 (LABEL)
- 7) WEIGHT: 0.11 lbs

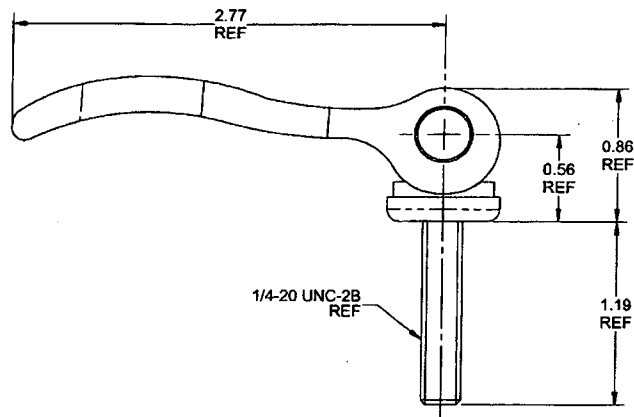
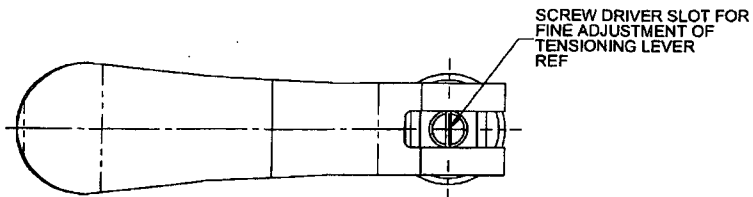
B	RE-DRAWN IAW QSI 043/044: SUPPLIER AND SUPPLIER P/N WERE "NORCO" AND "25-5129-01". REF: PAR12-159.	MB	12.01.31
A	NEW ISSUE	BW	95.02.24
REV.	DESCRIPTION	BY	DATE
DESIGN	BW		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.01.31		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D2372** REV. B
SHEET 1 OF 2
TITLE **QUICK RELEASE** SCALE NTS

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SPECIFICATION CONTROL DRAWING



D2372-1 CAM LEVER

DART PART NUMBER	DESCRIPTION	SUPPLIER	SUPPLIER PART NUMBER	MATERIAL	WEIGHT
D2372-1	CAM LEVER	REID TOOLS (PREFERRED)	KCL-208	HANDLE: ALUMINUM	0.10 lbs
		McMASTER-CARR (ALTERNATE)	5720K52	CAM WASHER: NYLON THREADED STUD, PIN, CAP WASHER: STAINLESS STEEL	

RELEASED
2012-02-06

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE TABLE

DESIGN	BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BY		
CHECKED	BY	DRAWING NO.	REV. B
MFG. APPR.	BY	D2372	SHEET 2 OF 2
APPROVED	BY	TITLE	SCALE
DE APPR.	BY	QUICK RELEASE	NTS
DATE	12.01.31	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO28761

Purchase Order Date 6/10/2015

PO Print Date 6/10/2015

Page Number 1 of 2

Order From :

VU-REI001

Ship To : DART AEROSPACE LTD

ESSENTRA COMPONENTS
62919 COLLECTION CENTRE DRIVE
CHICAGO, IL 60693-0629
US

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED

Contact Name

Vendor Phone 800 253 0421

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Ship To Contact

Terms

Net 30

Ship To Phone

Currency

USD

Ship Via:

FedEx Overnight collect

FOB

FCA - (Free Carrier)

Ship Acct:

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
Line Comments		Promise Date					
Delivery Comments							
1	KCL-208	Cam Lever	6/12/2015		10.00	\$22.67	\$226.70
			Yes		Each		
			6/12/2015				
AS PER DWG D2372 REV. B B133398							
						Line Total:	\$226.70
2	BLRS-002	Quick Release Pin (3/16" x 1.5")	6/12/2015		10.00	\$29.14	\$291.40
			Yes		Each		
			6/12/2015				
						Line Total:	\$291.40
3	BLRS-010	Quick Release Pin (1/4" x 1")	6/12/2015	FN	10.00	\$21.92	\$219.20
			Yes		Each		
			6/12/2015				

Note:

6/10/2015



7240 Global Drive
Louisville, KY 40258
Phone: 800-847-0486
Fax: 814-898-1638
www.essentracomponents.com

DELIVERY NOTE#:



P83907201789673

CUSTOMER PO#



PO28761

Bill To: DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
CANADA

Ship To: DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
CANADA

CUSTOMER NO		ORDER #	SHIPPED VIA	SHIP DATE	
45215650		1789673	FXIP FedEx International Priority	06/11/15	
ORD LN	Item Description	Original Quantity	Quantity Shipped	Backorder Quantity	UM
1	KCL-208 2.77 SS ADJ CAM LEVER 1/4-20 X Country Of Origin: DE	10.000	10.000		EA
2	BLRS-002A 3/16 X 1-1/2 SS BL PIN Country Of Origin: US	10.000	10.000		EA
3	BLRS-010A 1/4 X 1 SS BL PIN Country Of Origin: US	10.000	10.000		EA
4	CBL-1240 1/16" 7 X 7 STEEL CABLE 100 FOOT LGNTH Country Of Origin: US	5.000	5.000		EA

This is to certify that the above material shipped against your purchase order is in conformance with all known requirements, specifications and drawings in effect at the time of manufacture. All applicable physical, functional, dimensional and material test reports are on file at our facility, and may be inspected by your representative upon request.

Tracy D. Sandell
Quality Manager

1. Vendor(Name and Address)

7240 Global Drive
Louisville, KY 40258

Commercial Invoice

2. Date of direct shipment to Canada

June 11, 2015

3. Consignee (Name and address) DART AEROSPACE 1270 ABERDEEN ST HAWKESBURY, ON K6A 1K7 CANADA		4. Purchasers name and address (If other than consignee) DART AEROSPACE 1270 ABERDEEN ST HAWKESBURY, ON K6A 1K7 CA		
5. Other references (Include Purchase order's number) LOAD: 977210		6. Country of origin GERMANY		
7. Country of transshipment CANADA		8. Transportation: Give Mode and Place of Direct Shipment to Canada FXIP		
9. Currency of Settlement US Dollars		10. Item Description PLASTIC PROTECTIVE CAPS & PLUGS TARIFF ITEM# 3923.50.0000-7		
Pkgs.	Item Description	Quantity Shipped	Unit Price	Total
1 CTNS	KCL-208	.000PCS	23.72	.00
Shipping Clerk: Michael Kovach		Part Weight .00	Tare Weight .00	Invoice Total .00